

ABSTRACT

A molded article with multi-material or color and soft portions and a method of making the same is disclosed. The molded article comprises a multi injection substrate, and a coverstock or skin. The article is formed by a process wherein the coverstock or skin is secured within the mold, a first material is injected into a first cavity, a retractor member is moved to define a second cavity, and a second material is injected into the second cavity. The first and second materials may be different types of plastic, different colors, or combinations thereof. The first cavity is defined by two mold sections (e.g., a cavity and a core) and the retractor member. The second cavity is also defined by the two mold sections, the retractor member, and the (at least partially) hardened first material. The first material may be configured to couple to the second material by a locking interface provided by recesses and/or projections on the mold sections. A method of forming the flexible skin may include coupling a compressible material to the skin; positioning the skin and compressible material in a mold; and forming a rigid substrate around the skin and compressible material providing a first soft region wherein the compressible material is disposed between the skin and the substrate so that a first soft region is defined by the compressible material.